

# FAI Work Order ID 54683

December 16, 2009 10:45:19 AM



Page 1

Item ID: D3889-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Floor

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*09/12/16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3889

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*B 9-12-16*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*09/12/17* *(1)*

*B 9-12-16*

**Work Order ID 54683**

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Page 2

Item ID: D3889-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Floor

Start Date: 12/16/09 Start Qty: 1.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

SS 09/12/17



QC

Memo

0.00

Quality Control



130

0.00



Small Fab

Memo

0.00

Small Fab

Debur if necessary

SS 09/12/17

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SS 09/12/17



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Item ID: D3889-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Floor

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1 - Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: 1113174

9509/12/17 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 802/12/16

②

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

SIAN  
HAI

9/12/18 ③

**Work Order ID 54683**

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Item ID: D3889-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Floor

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21

RL 09/12-18

①

# Picklist Print

December 16, 2009 10:45:18 AM

Page 1

Work Order ID: 54683

Parent Item: D3889-041

Parent Item Name: Panel, Floor

Comments:

Start Date: 12/16/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,011.175	8.6237			
GE PLASTICS LEXAN SHEET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	2011.175198	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	1591.15667	

D3889-3

Manufactured No

140

Each

0.0000

1.0000



Gasket

B 54687

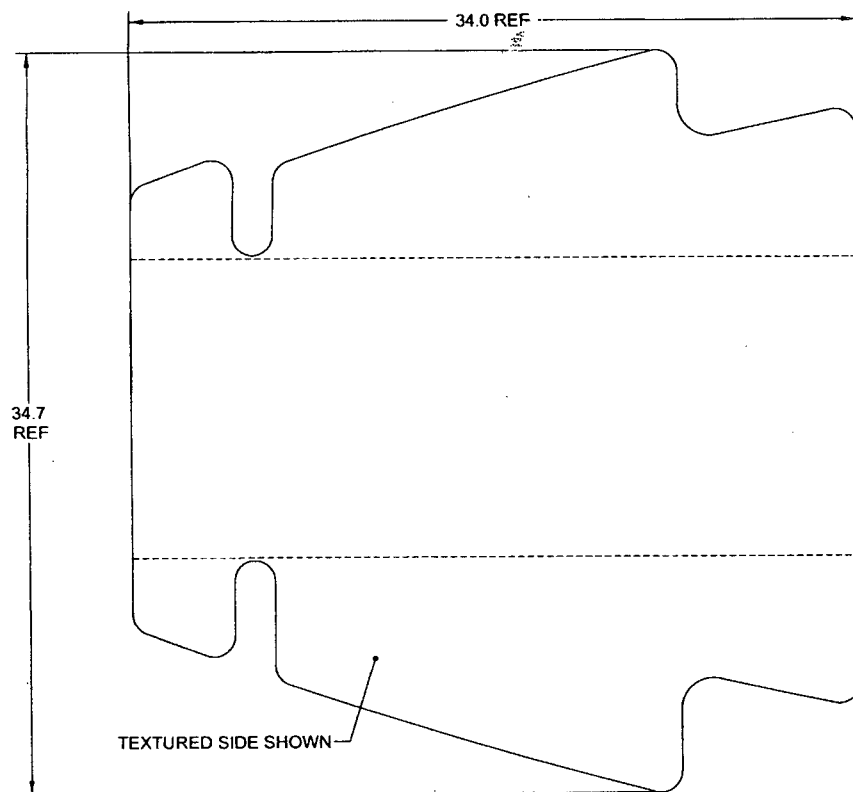
88 02/12/17 ①



310  
12.0  
0

## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

D3889-1 PANEL

D3889-3 GASKET

8

6

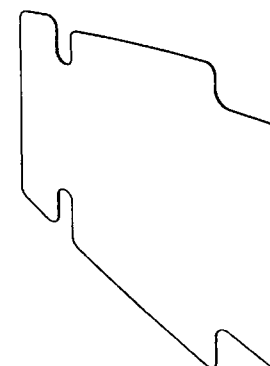
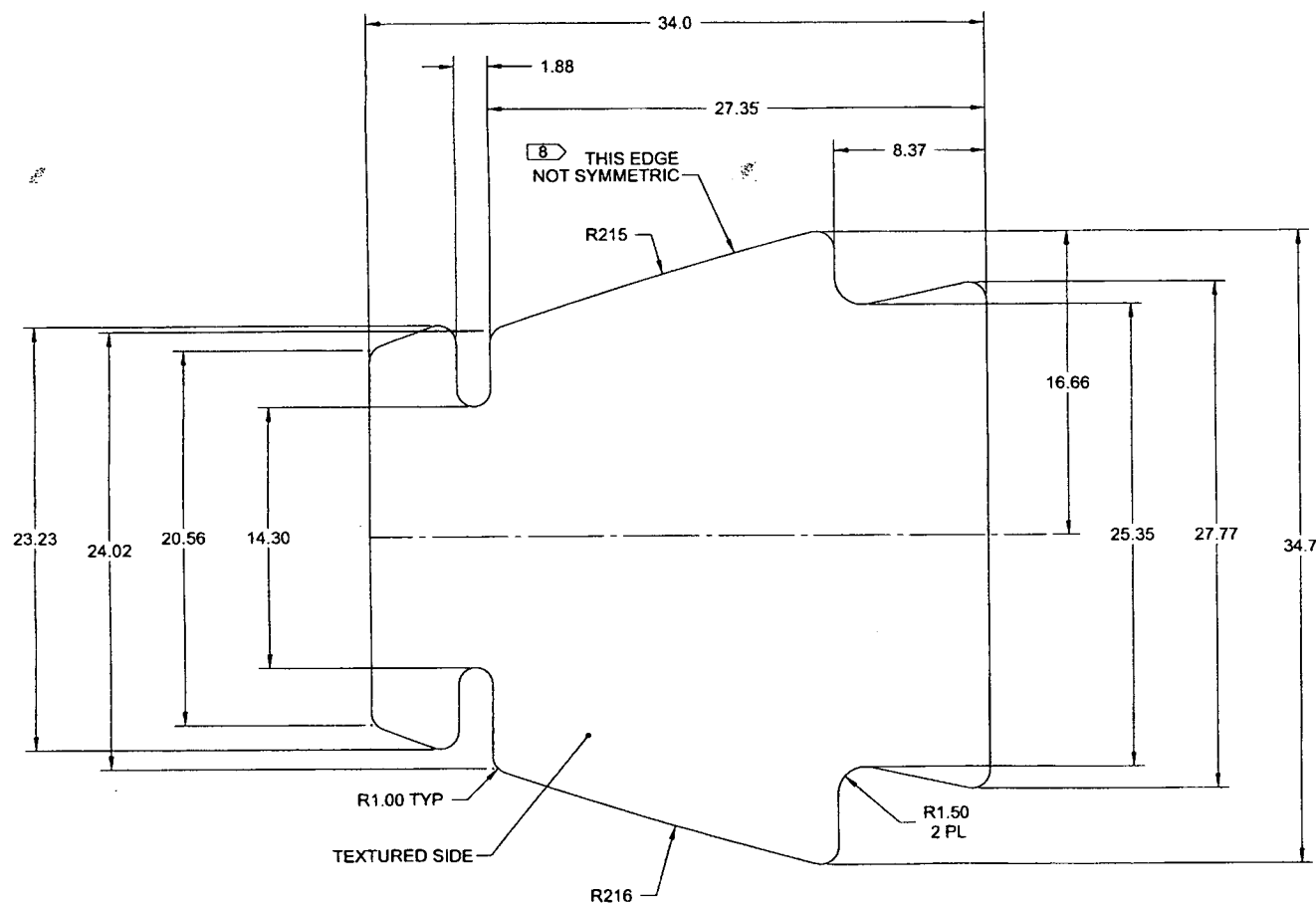
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54683

BS 09-12-16

RELEASED  
9/6/16 MP

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	WLD	D3889	SHEET 1 OF 3
APPROVED	WLD	TITLE	SCALE
DE APPR.	WLD	PANEL, FLOOR	NTS
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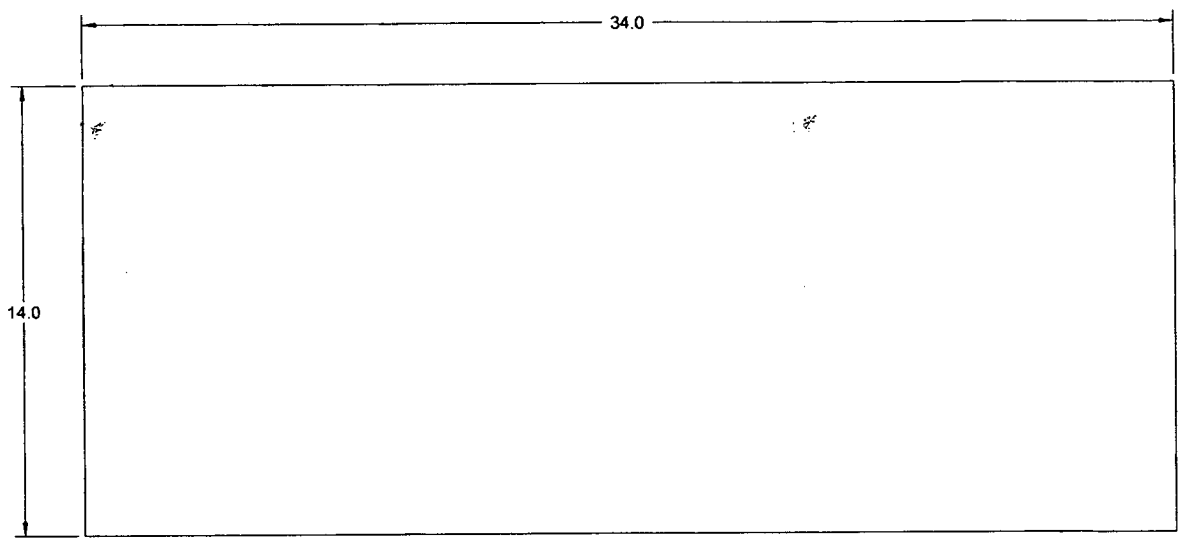
RELEASED  
09/06/14

# **D3889-1 PANEL**

- NOTES:
- MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
  - FINISH: NONE
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - UNITS: INCHES UNLESS OTHERWISE NOTED
  - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - IDENTIFICATION: NONE
  - WEIGHT: 4.95 lbs
  - PART SYMMETRIC ABOUT CENTERLINE EXCEPT AS SHOWN

DESIGN	WLB 54683	DART AEROSPACE LTD	
DRAWN	WLB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WLB	DRAWING NO.	REV. A
MFG. APPR.	WLB	D3889	SHEET 2 OF 3
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8 7 6 5 4 3 2 1



D3889-3 GASKET

RELEASED  
09/08/16 MP

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

*W/O 34683*

DESIGN	<i>W/O</i>	<b>DART AEROSPACE LTD</b>	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3889	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1